

# Work Order ID 68114

Wednesday, April 06, 2011 2:58:32 PM



Page 1

Item ID: D2842-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, 206 Float

Start Date: 4/6/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-04-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2842	Rev B

100 Large Fab 0.00



Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842  
2-Drill D2842-1 using Jig DT8271 as per Dwg D2842  
3-Deburr and bevel ends for welding

*11.04.06*

*3*

*φ*

110 QC6- Inspect dimensions to drawing 0.00



QC

Memo

0.00

Quality Control

*11.05.05*

*3*

120 Weld per dwg A/R Aluminum rod Batch: 114703 0.00



Large Fab

Memo

0.00

Large Fab

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per Dwg D2842

2-Grind end cap weld flush

*11.05.05*

*3*

*φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC <sup>1</sup> Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

3 0 861105/09

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/05/09

(43  
LM)

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

3 LH 0 m/11/05/10

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Page 3

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Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

3

BK 11-5-10

170



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: M114703 0.00

Large Fab

0.00

Memo

1-Remove alodine prior to welding.  
Weld end cap as per Dwg D2842.  
2-Grind end cap weld flush.

0.00

P/E 11-05-11

3

Ø

180



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S 4/6/11

23

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID:	D2842-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly, 206 Float					
Start Date:	4/6/2011	Start Qty:	3.00		Cust Item ID:	
Required Date:	4/12/2011	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				x3			
Quality Control						44			

191	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing	***Touch up step with alodine per qsi 005 prior to powder coat***								

200	White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:00								
	OVEN TEMPERATURE: 320								
	FINISH TIME: 2:30								

M116964

3 LH ~~3~~ M-L 11/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, April 06, 2011 2:58:32 PM



Page 5

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
220	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D2842								
	2-Wing Walk as per Dwg D2842 and QSI 005 4.1								
	Batch: 117315								
230	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

3 BR 11-5-13

3 BR 11-5-13

~~3 BR 11-5-13~~  
+3  
LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, April 06, 2011 2:58:32 PM



Page 6

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Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

RP 68113

11/5/18 750/30



Packaging

Memo

0.00

Packaging

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/18 750/30  
11-05-18 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, April 06, 2011 2:58:43 PM

Page 1

Work Order ID: 68114

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float



Start Date: 4/6/2011

Required Date: 4/12/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM□□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960C10L NAS1149C0332 ✓ Purchased

No

100

Each

0.0000

3

9



M117291



9 BR 11-5-13.

washer

D2622-120C

Manufactured

No

120

Each

33.0000

1

3



PK 11-04-06

Step Extrusion

## Location

## Loc Qty

## Loc Code

HALL

30

64409

30

3

WA

3

46910

2

64409

1

PK

D2734

Manufactured

No

120

Each

73.0000

2

6



PK 11-05-11

Step End Plate

## Location

## Loc Qty

## Loc Code

WA015

73

66143

73

6

D3459-3

Manufactured

No

120

Each

35.0000

2

6



PK 11-05-05

Float Step Mounting Plate

## Location

## Loc Qty

## Loc Code

ST017

35

62396

2

62956

33

2

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, April 06, 2011 2:58:43 PM

Page 2

Work Order ID: 68114

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 4/6/2011

Required Date: 4/12/2011

Start Qty: 3.00

Required Qty: 3.00

D3459-1 Manufactured No

220 Each

29.0000

2 6



Float Step Mounting Plate



11.05.05

## Location

## Loc Qty

## Loc Code

WA017

29

62955

29

6

MS27039C1-07 Purchased

No

220 Each

0.0000

3 9



screw

NAS1329C3KB130

Purchased

No

220 Each

23.0000

3 9



insert



M117423

9 BL 11-5-13

## Location

## Loc Qty

## Loc Code

FP-A

23

115719 ✓

23

9

NAS1515H3L Purchased

No

220 Each

337.0000

3 9



WASHER



9 BL 11-5-13

## Location

## Loc Qty

## Loc Code

FG

40

102472

40

ST277

297

113362 ✓

297

9 BL 11-5-13

Wednesday, April 06, 2011 2:58:44 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

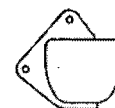
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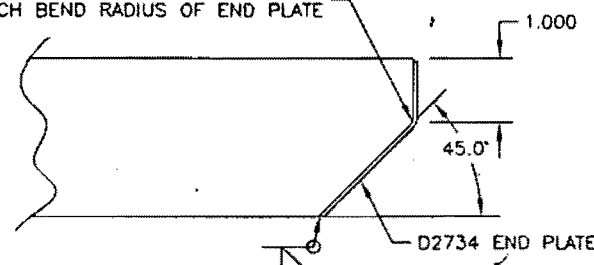


TO  
 ORDERING  
 CONTROLLED COPY  
 EMENT  
 NOTICE  
 ORDER  
 68114

pl-04-6



ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL  
NOT TO SCALE

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-11B	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AE5510KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C1DL	WASHER

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
05-11-14

DESIGN KE	UNNAN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2842	SHEET 1 OF 1	
DATE 05.09.23	TITLE 206L/407 FLOAT STEP ASSEMBLY		SCALE NTS	
A	98.10.13	NEW ISSUE		
B	05.09.23	RE-DESIGN, ADD D3459-1/-3		

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